

Work Order ID 72372

Monday, July 25, 2011 9:11:58 AM

Page 1

Item ID: D3170-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 7/25/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3170

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3170

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

6061 .000

B11-8-11

30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-11

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulos W

counts
638

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo
Debur*MAS*

0.00

0.00

Small Fab

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

30 x 6 M u / 08/13

150



QC

QC3- Inspect Part Finish

Memo

0.00

0.00

Quality Control

30 x 6 M u / 08/16

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

nlas



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location WH

0.00



Packaging

Memo

0.00

Packaging

11/8/16 30

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-05-14 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:01:45 PM

Page 1

Work Order ID: 72372

Parent Item: D3170-1

Parent Item Name: Spacer



Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 02.10.11 New issue KJ
IPP Rev:B 06-04-27 Manufactured in House JLM
IPP Rev:C Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased			No		sf	219.9000		0.75	2		



6061-T6 .080 Sheet



IB11-8-11

Location

Loc Qty

Loc Code

MAT021

219.9

116268

17.5

117285

202.4

117285

30

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DART

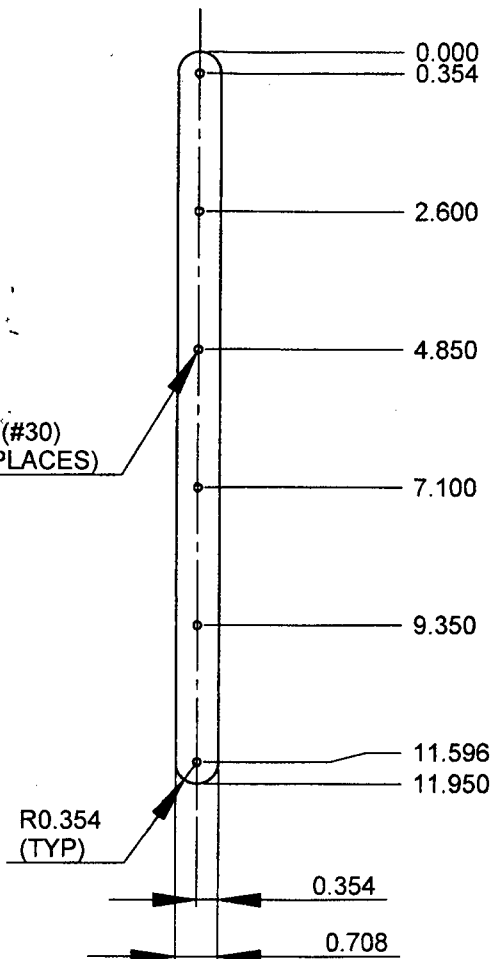
DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3170	REV. B SHEET 1 OF 1
DATE 06.05.30		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.30	ADD 6061-T6 MATERIAL	

RELEASED*06.06.20* *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *72372*

PH 11-07-28

$\phi 0.128$ (#30)
(TYP 6 PLACES)

**D3170-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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